

Date: Thursday, 10/04/2008 4:00:53 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPAD											
Job Number	: 38548			Part Number	: D356411											
Estimate Number	: 12785			Drawing Number	: D3564 REV D											
P.O. Number	:			Project Number	: N/A											
This Issue	: 10/04/2008	S.O. No.	:	Drawing Revision	: D											
Prsht Rev.	: NC			Material	:											
First Issue	: 11	Type	: SMALL /MED FAB	Due Date	: 30/04/2008											
Previous Run	: 37811			Qty:	30	Um:	Each									
Written By	:															
Checked & Approved By	: JB 08.4.10															
Comment	<table border="0"> <tr> <td>: Est Rev:A</td> <td>New Issue 07-03-08</td> <td>ec</td> </tr> <tr> <td>Est Rev:B</td> <td colspan="2">As per Rev C 07-07-09 JLM</td> </tr> <tr> <td>Est Rev:C</td> <td colspan="2">As per Rev D 07-09-09 JLM Verified By:EC</td> </tr> </table>							: Est Rev:A	New Issue 07-03-08	ec	Est Rev:B	As per Rev C 07-07-09 JLM		Est Rev:C	As per Rev D 07-09-09 JLM Verified By:EC	
: Est Rev:A	New Issue 07-03-08	ec														
Est Rev:B	As per Rev C 07-07-09 JLM															
Est Rev:C	As per Rev D 07-09-09 JLM Verified By:EC															

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	 48, Comment: Qty.: 1.48050 sf(s)/Unit Total : 44.41500 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 107676 1B 8-4-14
2.0	WATER JET	 FLOW WATER JET
3.0	QC2	 Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)***** Dwg Rev: D 1B 8-4-14 Prog Rev: D 1B 8-4-14
4.0	QC8	 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-4-14
5.0	BRAKE NC	 Comment: SECOND CHECK 1B 8-4-14
		 Comment: NC BRAKE 1B 8-4-14

Page 1

### Form: process

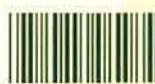
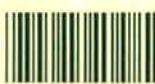
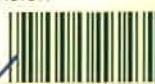
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 38548		Part Number: D356411
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429		 08/04/17 +32
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat M106615 → 107051 08-05-8 16x SP Weld hardcoat as per Dwg D3437 08-04-29 SP 6x		 P10
8.0	QC10	VISUAL INSPECTION OF GROUND WELDS 
Comment: VISUAL INSPECTION OF GROUND WELDS		 S 08/05/08 (H10)
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 S 08/05/08 (H10)
10.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		 M1 105642 08-05-06 16x 30ml/ltr
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 M-1 08/05/08 16x
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: F13-18		 08-05-08 X16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-05-07	7.0	Need 10 per completion of skid tubes 205. Qty 10 used on -3 split	J	0805-07	10 USED 08-05-07	0805-07	0805-07

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 4:00:53 PM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38548

Part Number: D356411

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38548
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

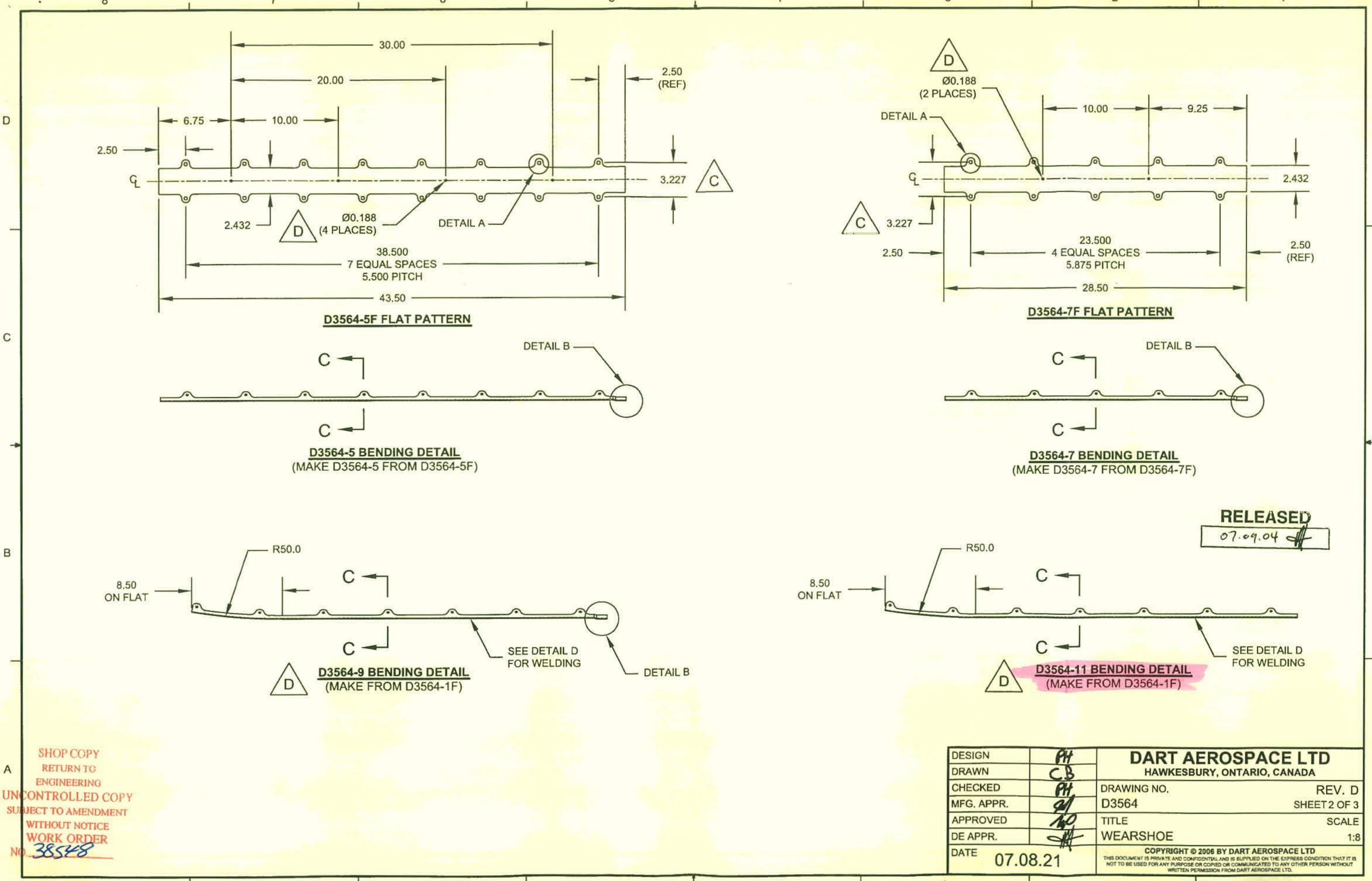
Measured by: <u>IB</u>	Audited by: <u>SB</u>	Prototype Approval: N/A
Date: <u>8-4-14</u>	Date: <u>08/04/15</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	✓

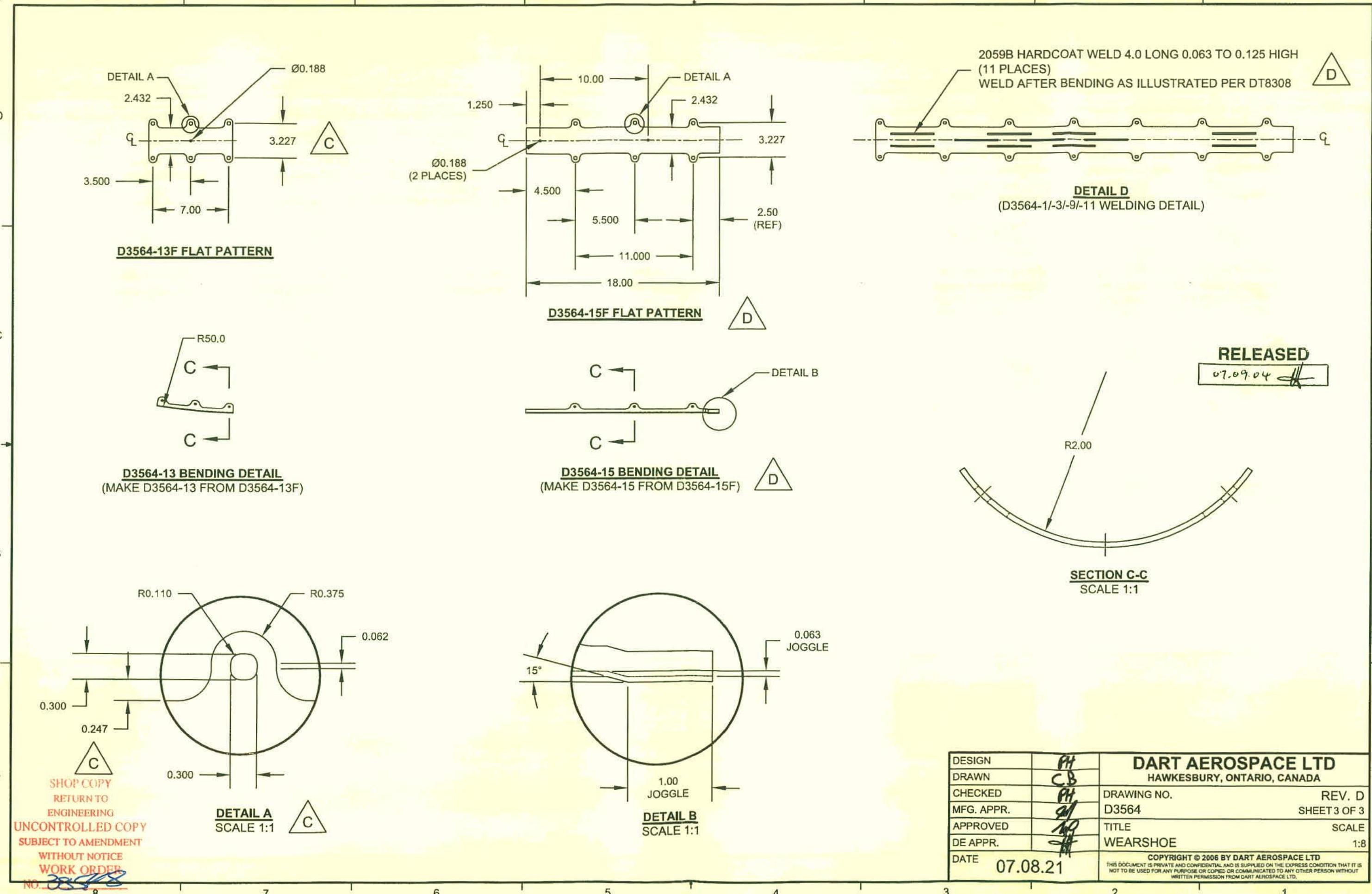






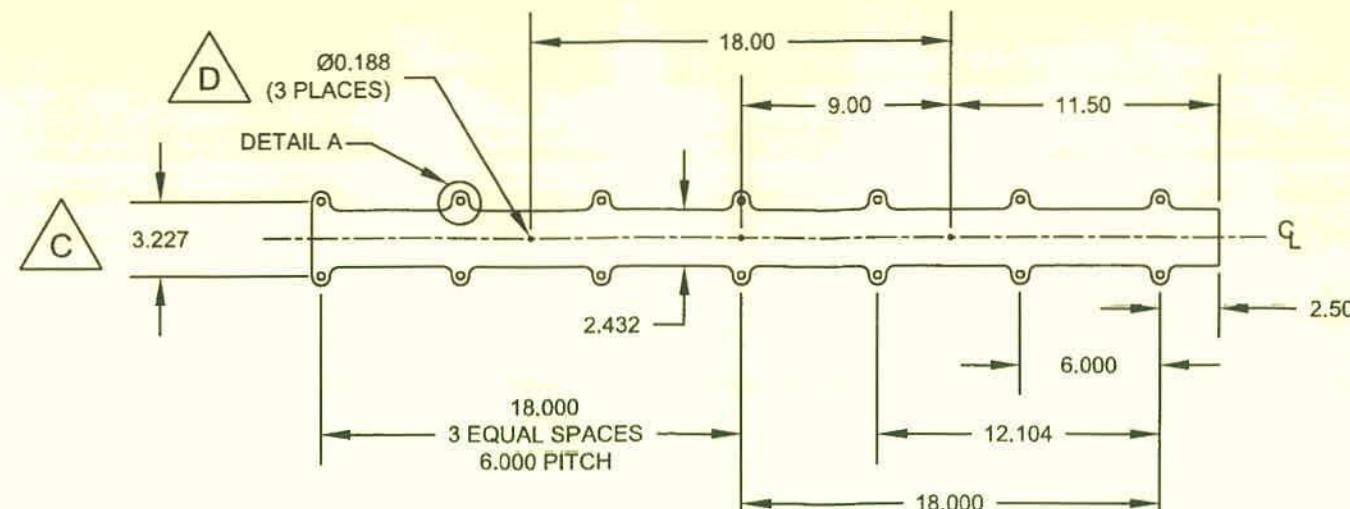






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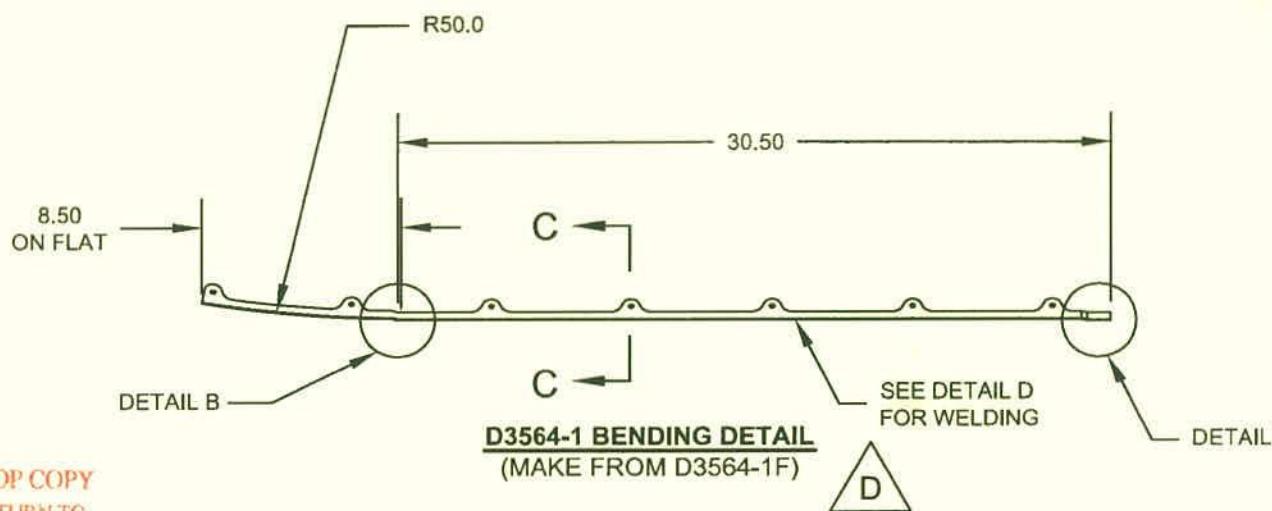


D3564-1F FLAT PATTERN

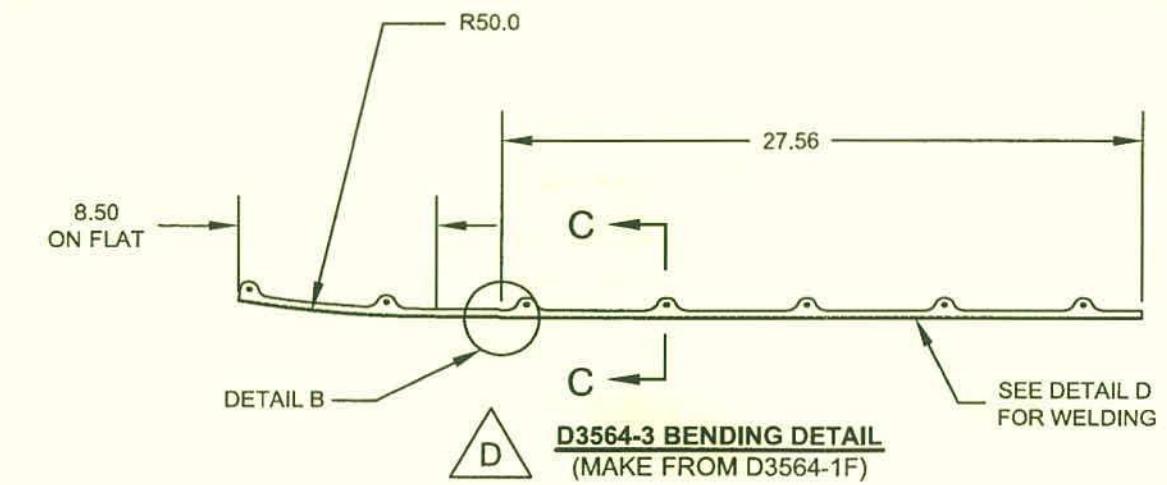
RELEASED

07.09.04

#



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 385528

D3564-1/3-5-7-9-11-13-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\frac{1}{2}$

WEIGHTS:  
D3564-1 1.85 lbs  
D3564-3 1.85 lbs  
D3564-5 1.93 lbs  
D3564-7 1.26 lbs  
D3564-9 1.85 lbs  
D3564-11 1.85 lbs  
D3564-13 0.38 lbs  
D3564-15 0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
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C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
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B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
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A	NEW ISSUE	PH	06.12.18
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REV.	DESCRIPTION	BY	DATE
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DESIGN	PH	DART AEROSPACE LTD	
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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
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CHECKED	PH	REV. D	
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MFG. APPR.	SI	SHEET 1 OF 3	
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APPROVED	10	SCALE	
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DE APPR.	SI	WEARSHOE	
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DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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